

Date: Tuesday, 15/07/2008 9:14:06 AM
 User: Julie Leccocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR DOUBLER		
Job Number	: 40476		Part Number	: D3594043		
Estimate Number	: 12681		Drawing Number	: D3594 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 15/07/2008	S.O. No. :	Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: //	Type	: SMALL /MED FAB			
Previous Run	: 39575		Due Date	: 30/07/2008 Qty: 10 Um: Each		
Written By	:					
Checked & Approved By	: JUO 08.15.08					
Comment	: Est Rev :A New Issue 07-01-22 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S080	6061-T6 .080 Sheet
Comment: Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s) 6061-T6 .080 Sheet Batch: 108433 FB 8-8-12		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: B FB 8-8-12 Prog Rev: B		
2-Deburr if necessary FB 8-8-12		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE FB 8-8-12		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK Sodol 10/13		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS PER DWG D3594 EFB 18/8/20 13x		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:14:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 40476

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 13

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JFL 08.08.20

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A 08/08/20

9.0 MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Anchor nuts

BATCH: 1107938

EJ 08/08/20

10.0 MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

BATCH: 11021

EJ 08/08/20

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

EJ 08/08/20 13

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/20 13

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST248

AS 08/08/20 X13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:14:06 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 40476

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594	Rev: A/B 08/07/14	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

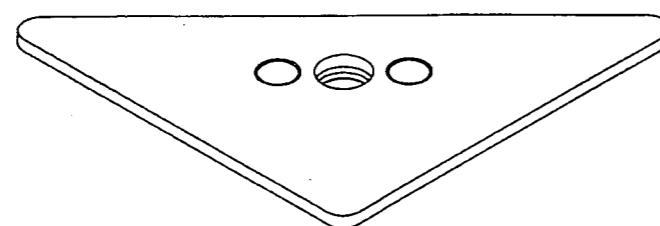
Measured by:	<u>LB</u>	Audited by:	<u>J</u>	Prototype Approval:	N/A
Date:	8-8-12	Date:	08/08/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	P/O D3594-043	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

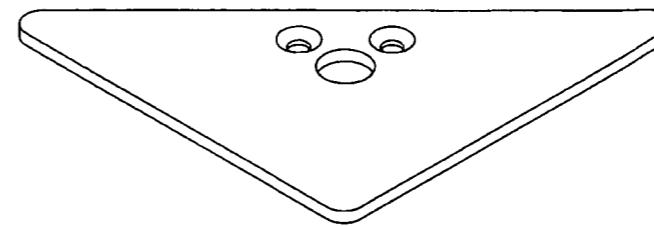
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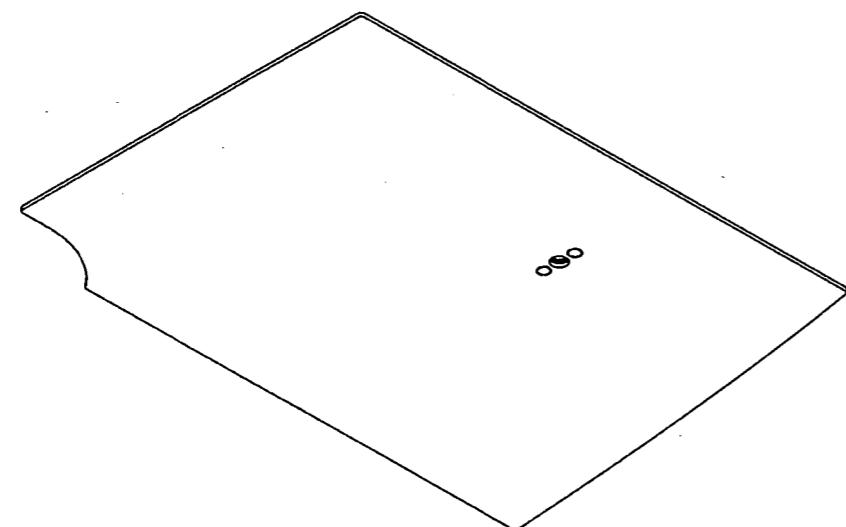
D3594-041 DOOR DOUBLER ASSEMBLY



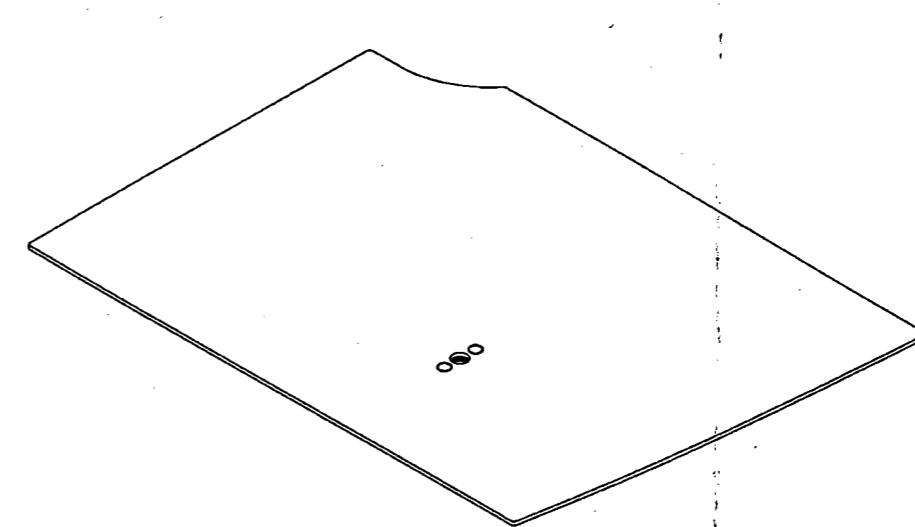
D3594-5 DOOR DOUBLER

C

C



D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

B

B

A

A

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08.05.14
10470

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WORK ORDER
NO. 10470

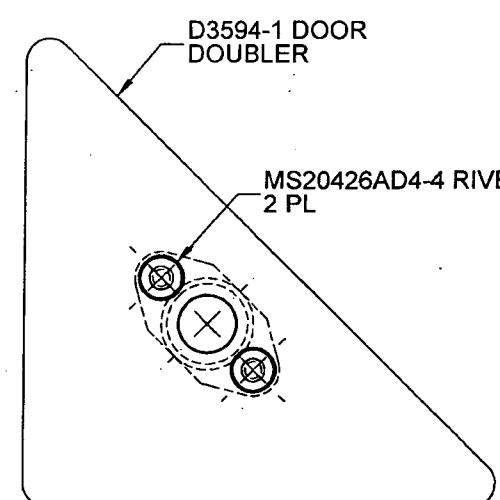
B	REFORMAT TO B SIZE DRAWING. SHEET 2 ADD -5.		AJS	08.05.14	
A	NEW ISSUE		MB	07.04.13	
REV.	DESCRIPTION			BY DATE	
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D3594 REV. B SHEET 1 OF 4		
DRAWN	AJS				
CHECKED					
MFG. APPR.					
APPROVED				SCALE NTS	
DE APPR.		TITLE DOUBLER			
DATE	08.05.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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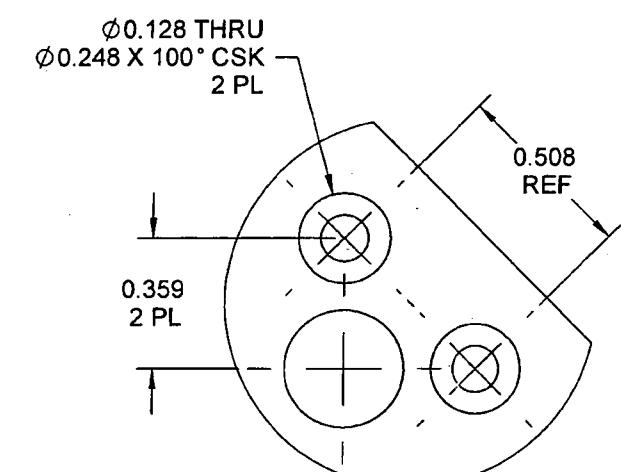
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK

D

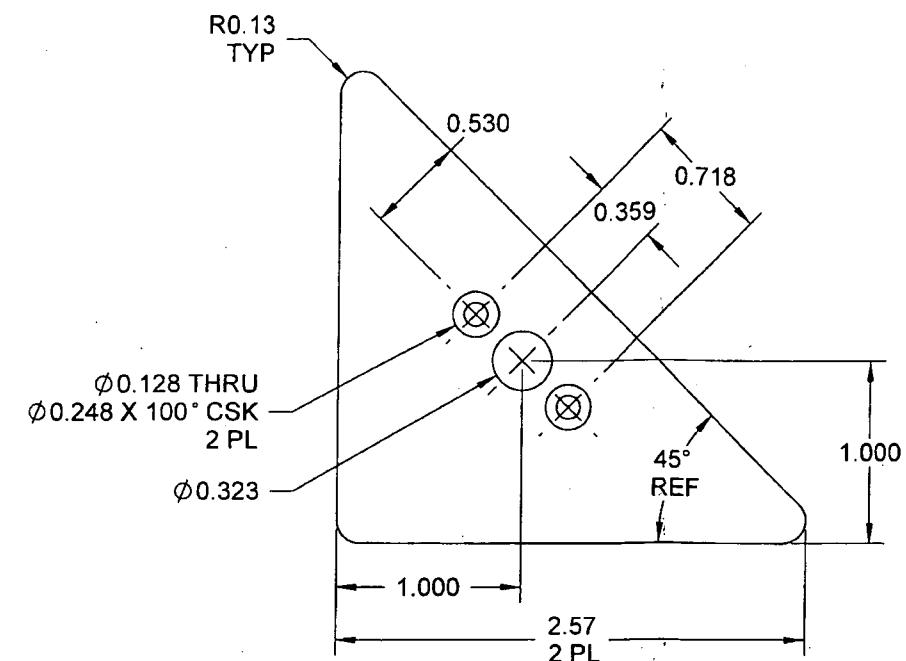
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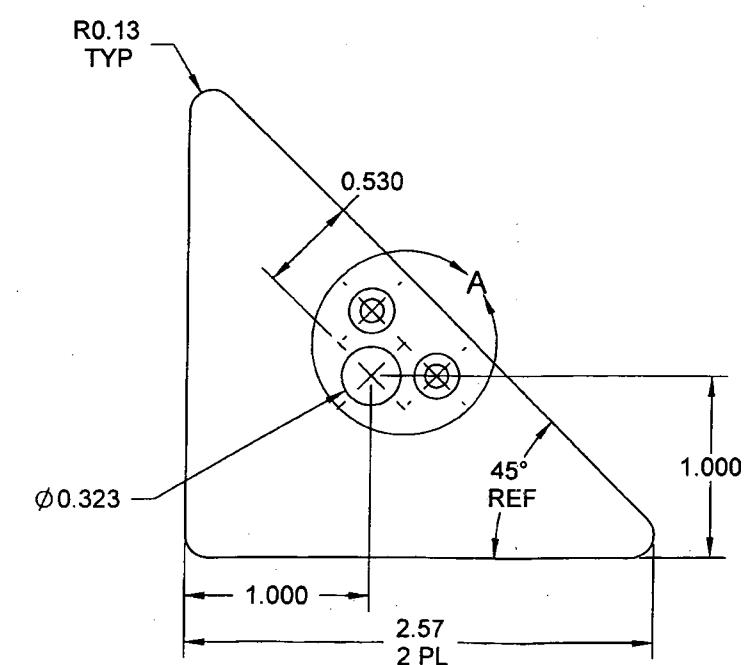
4 D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5 D3594-5 DOOR DOUBLER △ B

NOTES:

- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

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NO. 40470

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08.06.26/14

DESIGN	MB	DART AEROSPACE LTD
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. B
APPROVED		D3594
DE APPR.		SHEET 2 OF 4
DATE	08.05.14	TITLE DOUBLER SCALE NTS

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QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK

D

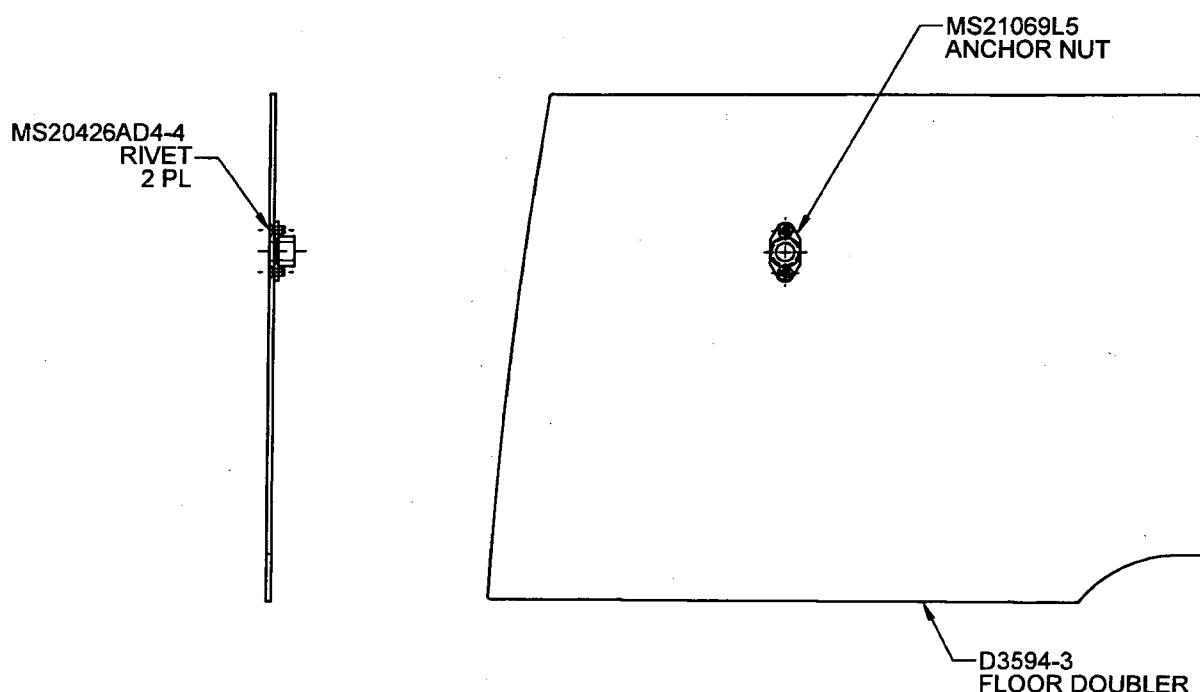
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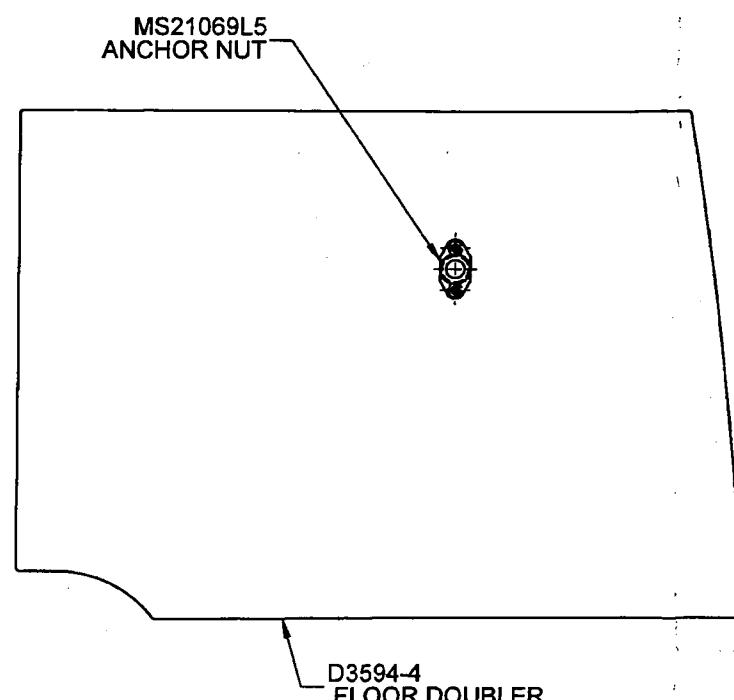
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D3594-043 FLOOR DOUBLER ASSEMBLY



D3594-044 FLOOR DOUBLER ASSEMBLY

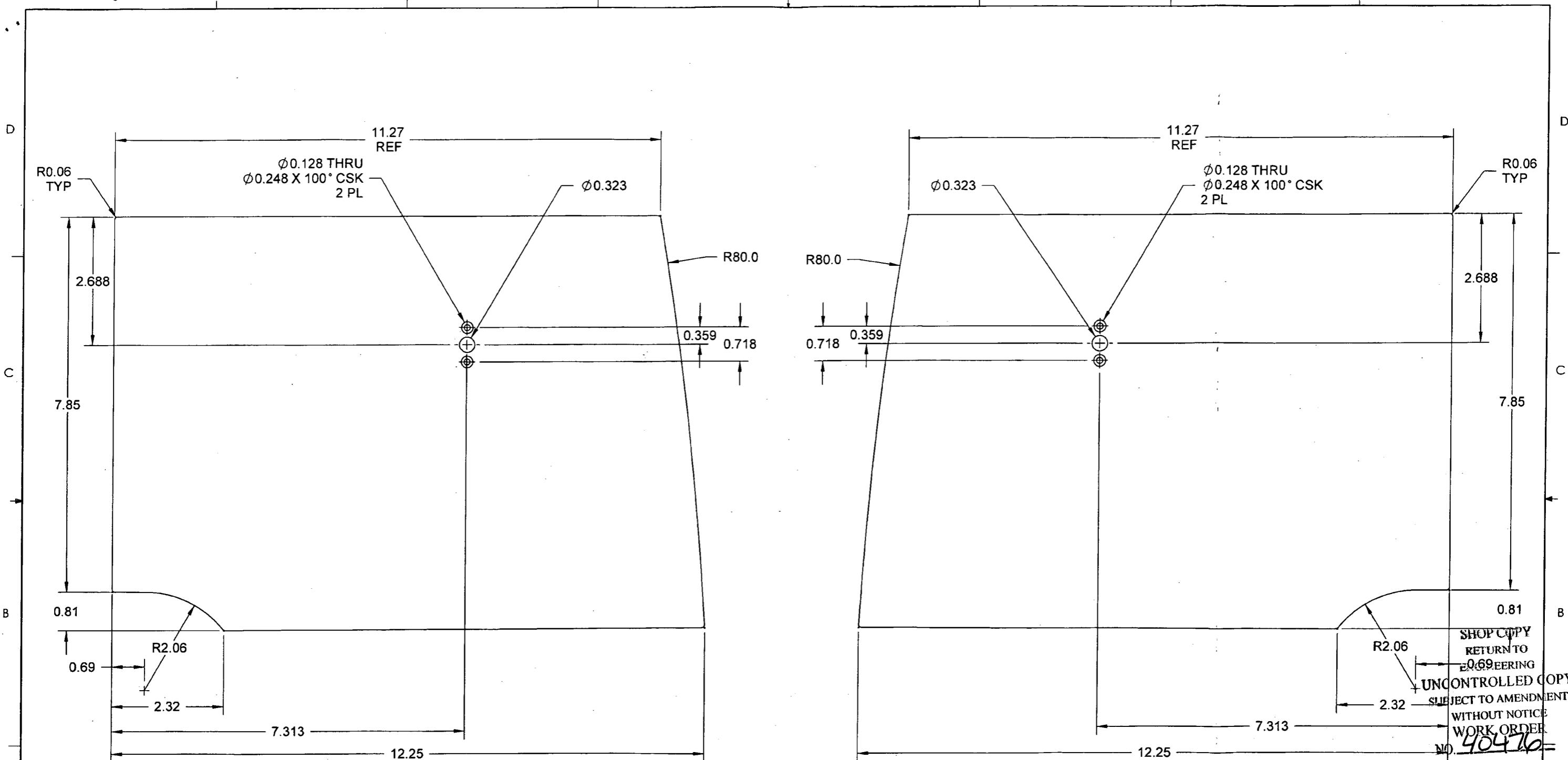
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	
MFG. APPR.		REV. B	
APPROVED		D3594	
DE APPR.		SHEET 3 OF 4	
DATE	08.05.14	TITLE	DOUBLER
SCALE NTS			
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8 7 6 5 4 3 2 1



DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	MB	
CHECKED		DRAWING NO. D3594
MFG. APPR.		REV. B
APPROVED		SHEET 4 OF 4
DE APPR.		TITLE DOOR DOUBLER ASSEMBLY
DATE	08.05.14	SCALE NTS
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